

Date: Friday, 24/10/2008 11:29:34 AM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CAP
Job Number : 42928	
Estimate Number : 10519	
P.O. Number :	Part Number : D2855
This Issue : 24/10/2008 S.O. No. :	Drawing Number : D2855 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 42806	Material :
Written By :	Due Date : 31/10/2008 Qty: 18 Um: Each
Checked & Approved By :	
Comment : Est: B 00.06.22 Added receiving step & removed P/O for powder coat EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O: 7431

Cast per Dwg D2855

Material Release Note Required

C 208110/24

(18)

2.0	D2855P	Cap
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 18.0000 Each(s)
 CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 08/4/25 (18)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------

**Comment:** DIMENSIONAL CHECK

S 08/6/29 (408)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1- Drill as per Dwg D2855 using DT8235

2- Open holes to 19/64"

3- Deburr

C 08/12/04 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 11:29:34 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 42928

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sos/2/04 (X18)

7.0

POWDER COATING

POWDER COATING



M 10 91 52



(18X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45
320 °C
9:15

M-L 08/12/05

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



22



Comment: INSPECT POWDER COAT

08-12-05

(X18)

9.0

ALS71032225

INSERT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 36.0000 Each(s)

INSERT

Pick:

Qty Part Number

Description

Batch

2 ALS7-1032-225
or AKS7-1032-225
or ALS4-1032-225
or AKS4-1032-225

Insert

M/00621

F2

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2855

F2 08/12/11

(18)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sos/2/04 (X18)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F2-7

F2 08/12/11

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 24/10/2008 11:29:34 AM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 42928

Part Number: D2855

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/11 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

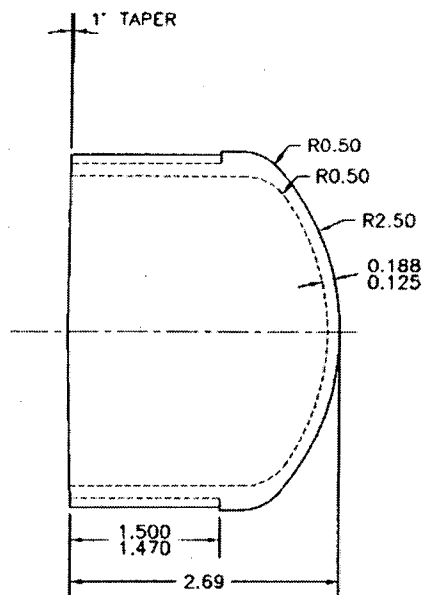
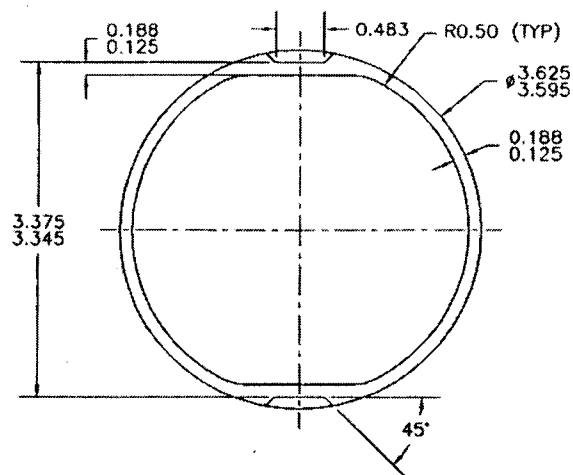
DART



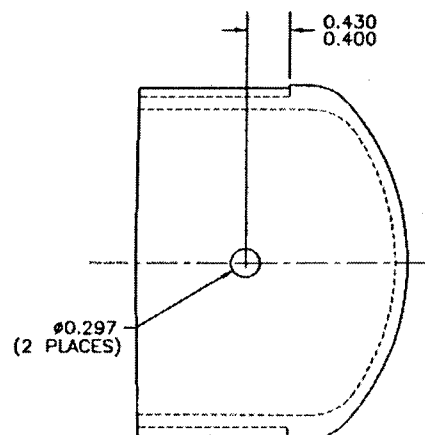
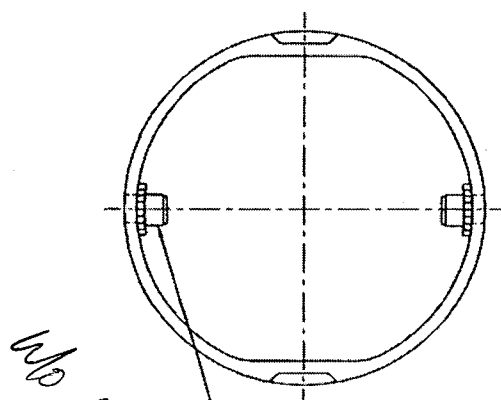
RELEASED
78.12.14 DS

DESIGN #	DRAWN BY	DART AEROSPACE LTD HAMKESBURT, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D2855	SHEET 1 OF 1
98.12.12		TITLE	SCALE
		CAP	NTS
A	96.12.12	NEW ISSUE (WAS D2575 REV. E)	

D2855 CASTING DETAIL



D2855 FINISHING DETAIL



Wp 42928

INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
(2 PLACES)

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
MATERIAL: CAST ALUMINIUM ALLOY A356.2 (F)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Aluminum Foundry Ltd

714-716 Calais

Dorval, Québec H9P 2P3

Tel: (514) 631-1331

Fax: (514) 631-8448

Packing Slip

Packing Slip No.:

32829

Date:

Nov 21, 2008

Page:

1

Sold to:		Ship to:	
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7		DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7	
Order No.: 7431		Sold By:	
Shipped By: FEDEX		Ship Date: Nov 21, 2008	
Tracking No.: 8491 8012 0924			

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A	30
Comment:			

**71 CERTIFICAT DE CONFORMITÉ
C : RTIFICATE OF COMPLIANCE**

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

714 716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expedé à / Shipped **DART AEROSPACE**

A.F. & P.W. Série no./Serial no. _____

1270 Aberdeen Street

Packing
Date: **21/11/2008** **Slip No.** **32829**

Hawksbury, ON, K6 1K7

Votre No. Commande **00007431**
Your order No. _____

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
30	D 2855 CAP	Z098046	A356.2 <i>S 05/11/09</i>	Ingot#851118

**Analyses
Analysis (as in Ingot)**

(Si)	7.00%	(Al)	balance
(Fe)	0.06%		
(Cu)	0.00%		
(Mn)	0.00%		
(Mg)	0.42%		
(Zn)	<0.01%		
(Ti)	0.16%		

Donnée / Yield : **Résistance à la tension : / Tensile Strength :**

Allongement par pouce carré : / P.S.I. Elongation : _____ **%**

Pour et au nom de / For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep : _____
Par/Per : _____